












Date: Tuesday, 14/10/2008 3:39:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2893-1
Job Number	: 42596	Part Number	: DSK078
Estimate Number	: 13234	Drawing Number	: DSK078 REV.A
P.O. Number	:	Project Number	: N/A
This Issue	: 14/10/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 24/10/2008 Qty: 10 Um: Each
Previous Run	: 42374		
Written By	:		
Checked & Approved By	: <u>JUL 08.10.14</u>		
Comment	: est rev A. 08.03.13 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6104005	Round Billet, 17-4	
			(10)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Support <u>SA 0811127</u> <u>REL: B43150</u>			
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE	
			(10)
Comment: MORI SEIKI CNC LATHE LARGE Turn blank as per Folio FA081 <u>SA 0811127</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			(10)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 0811127</u>			
4.0	QC8	SECOND CHECK	
			(10)
Comment: SECOND CHECK <u>SA 0811128</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			(10)
Comment: PACKAGING RESOURCE #1 Identify and Stock in Kanban Location: <u>CNC</u> <u>SA 0811125</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 3:39:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 42596

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No , DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42596
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.954	4.953	4.954	4.953	4.950
C	3.064	3.084		3.071	3.074	3.074	3.073	3.074
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.102	.100	.100	.100	.100
F	2.934	2.954		2.941	2.944	2.944	2.943	2.944
G	2.166	2.186		2.177	2.177	2.176	2.176	2.176
H	3.890	3.910		3.896	3.893	3.893	3.900	3.900
I	0.914	0.934		.925	.925	.925	.925	.925
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.109	0.129		.117	.115	.115	.120	.120
L								
M								
N								
O								
P								

Measured by: SD Date: 08/11/27

Audited by: MK Date: 08/11/28

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42596
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET



First Article



Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.709	2.710	2.710	2.710
B	4.946	4.966		4.947	4.956	4.953	4.953	4.953
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.925	.925	.925	.925	.925
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.109	0.129		.118	.119	.118	.118	.118
L								
M								
N								
O								
P								

Measured by: SA Date: 08/11/27

Audited by: ML Date: 08/11/28

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries